

# Work Order ID 68233

Friday, April 08, 2011 3:03:13 PM



Page 1

Item ID: D3953-15

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Bracket

Stop



Start Date: 4/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 20.00



Customer:

Ship 14/04

Reference:

Approvals:

Process Plan:

*MF*

Date:

11-04-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev: *C*

Prog Rev: *C*

304.128

2-Deburr if necessary

B11-14-13

24

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-14-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68233**

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Page 2

Item ID: D3953-15

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Setup Start



Revision ID:

Stop



Item Name: Gas Spring Bracket

Start Date: 4/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<u>M</u>	<u>11</u>	<u>04</u>	<u>13</u> (24)
130  Small Fab Small Fab	Memo 1- CHAMFER HOLE AS PER DWG 2- DEBURR IF NECESSARY	0.00  0.00							(24X)
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>M</u>	<u>11</u>	<u>04</u>	<u>14</u> (24)

Handwritten notes:  $\Rightarrow$  m-d 11/04/14

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

**Work Order ID 68233**

Friday, April 08, 2011 3:03:13 PM



Page 3

Item ID: D3953-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Bracket

Start Date: 4/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 056

0.00



Packaging

Memo

0.00

Packaging

4/4/15 (2)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/4/15 (2)MF  
11-04-15

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, April 08, 2011 3:03:09 PM

Page 1

Work Order ID: 68233

Parent Item: D3953-15

Parent Item Name: Gas Spring Bracket



Start Date: 4/8/2011


Required Date: 4/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC  
DD 10.03.02 verified by:EC

IPP Rev:B as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	15.5000	0.0197	0.414737	.5		



B114-13

Location

Loc Qty

Loc Code

MAT020

15.5

116623

15.5

116623

(24)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

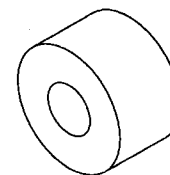
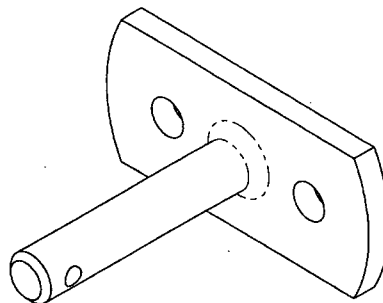
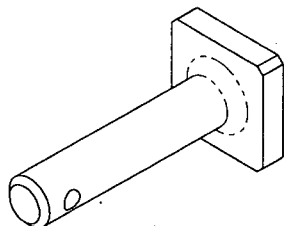
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



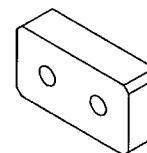
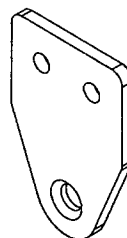
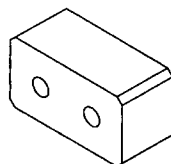
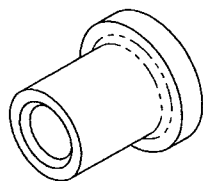
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



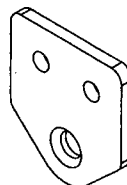
**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

**RELEASED**  
R 2010-02-26

C	PARTS -19 & -21 ADDED (SHT 18.4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); G SYMM WAS G SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED, REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

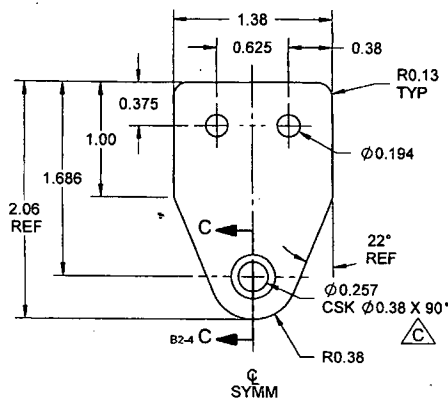
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

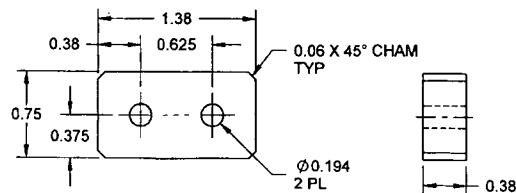
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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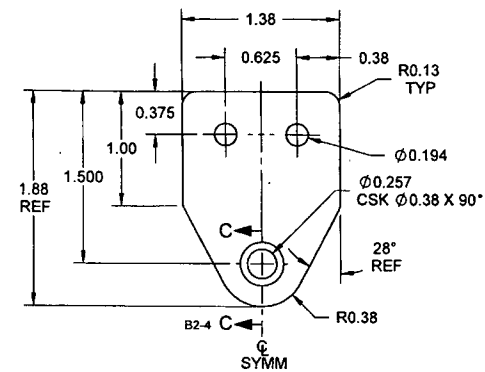
**NOTE:** Date & initial all entries



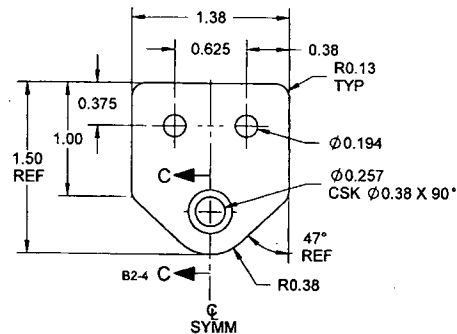
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



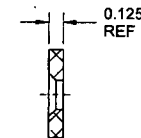
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)



**SECTION C-C**

**NOTES:**

- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 17: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs  
-17: 0.10 lbs  
-19: 0.07 lbs  
-21: 0.06 lbs

**RELEASED**  
2010-02-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3953</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>6-8223</i>
<b>Description:</b> Gas Spring Bracket		<b>Part Number:</b>	D3953-15
<b>Inspection Dwg:</b> D3953 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	.194	<i>✓</i>		V <i>BoZ</i>	
Ø0.257	+0.006/-0.001	.258	<i>✓</i>		V	
0.375	+/-0.010	.378	<i>✓</i>		V	
0.625	+/-0.010	.623	<i>✓</i>		V	
1.38	+/-0.030	1.387	<i>✓</i>		V	
0.38	+/-0.030	.38	<i>✓</i>		V	
1.00	+/-0.030	1.00	<i>✓</i>		V	
1.686	+/-0.010	1.682	<i>✓</i>		V	
2.06	+/-0.030	2.062	<i>✓</i>		V	
0.125	+/-0.010	.119	<i>✓</i>		V	

<b>Measured by:</b> <i>VB</i>	<b>Audited by:</b> <i>M. A. T.</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>11-4-13</i>	<b>Date:</b> <i>11-04-13</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
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